Work Order ID 69286

Friday, May 06, 2011 11:50:01 AM

Item ID: D2564 **Accept** **Setup Start**

Revision ID:

Item Name: Mounting Angle **Stop**

Start Date: 5/6/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 5/9/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** M **Date:** 11-05-6 **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D2564 / Rev B1									
100	BAND SAW	0.00				40			
Bandsaw	**Memo**	0.00							
Jeaspa Bandsaw	Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)								
110	HAAS CNC VERTICAL MACHINING #1	0.00				40			
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA276 Rev: ____ & Dwg D2564 Rev: ____ 2-Deburr if necessary Manual Mill								
120	QC2- Inspect parts off machine FAI/FAIB	0.00				40			
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 69286

Friday, May 06, 2011 11:50:01 AM

Item ID: D2564
Revision ID:
Item Name: Mounting Angle

Accept

Setup Start
Stop

Start Date: 5/6/2011 **Start Qty:** 20.00
Required Date: 5/9/2011 **Req'd Qty:** 20.00
Reference:

Cust Item ID:
Customer:

Run Start
Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check	0.00	B.A 11/05/16			40	ø		
	Memo	0.00							
140 Packaging Packaging	Identify as per dwg & Stock Location:_____	0.00				11/5/16	40		
	Memo *** STOCK IN STEP CELL***	0.00							
150 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						11/5/18	
	Memo	0.00							

11-05-18
40

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

Friday, May 06, 2011 11:50:07 AM

Work Order ID: 69286

Parent Item: D2564

Parent Item Name: Mounting Angle

Start Date: 5/6/2011 **Required Date:** 5/9/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP: □D□02.09.09□Re-format; Added FA276 Folio□KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6207 Angle Extrusion		Manufactured	No			100	f	0.0000	0.0916	1.928421			

M115 776

ML06114A1.000W.125

~~2.44~~ 4.8 f.

11/05/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	69286
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564 **Rev:** B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	.990	✓		RA26	Vern
0.625	+/-0.010	.630	✓		"	"
Ø0.257	+/-0.010	Ø.257	✓		"	
1.000	+/-0.010	1.001	✓		RA26	Var
1.000	+/-0.010	1.001	✓		RA26	Var
R0.375	+/-0.010	R.375	✓			RAD Gauge

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/05/16	Date:	11/05/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M		
CHECKED: BW	APPROVED: BW	DRAWING NO. D2564	REV. B SHEET 1 OF 1
DATE: 96:04:30		TITLE: MOUNTING ANGLE	SCALE: 1:1
B	97:05:06	MODIFIED DIMENSIONS	
B1	HRT 02.09.17	R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.000	

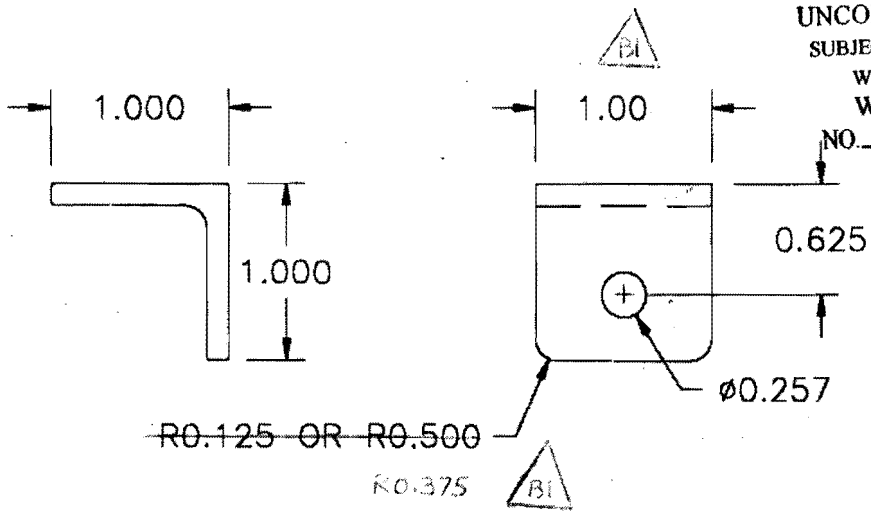
DART

COPY ISSUED

RELEASED 97/05/06 BW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER
NO. 69284

pl 11-05-6



NOTES

1) MATERIAL: 6061–T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D6207-XXX ANGLE EXTRUSION

2) BREAK ALL SHARP EDGES 0.005 - 0.015

3) TOLERANCES PER DART 651 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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